

Date:
User:Thursday, 9/14/2006 7:30:34 AM
Kim Johnston

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BAFFLE & DEFLECTOR ASSEMBLY |
| Job Number : 28581 | |
| Estimate Number : 12223 | |
| P.O. Number : N/A | Part Number : D3467049 |
| This Issue : 9/14/2006 S.O. No. : N/A | Drawing Number : D3467 REVB |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 26976 | Material : N/A |
| Written By : <u>JA 06 09 14</u> | Due Date : 10/6/2006 Qty: 4 Um: Each |
| Checked & Approved By : <u>JA 06 09 14</u> | |
| Comment : Est Rev: A New Issue 06-04-24 JLM Est Rev:B As per Rev B 06-05-24 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|---------|-----------|
| 1.0 | D346715 | DEFLECTOR |
|-----|---------|-----------|

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3467-15 Deflector B 28592

mf. 06/09/28. (8)

| | | |
|-----|---------|--------|
| 2.0 | D346713 | BAFFLE |
|-----|---------|--------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-13 Baffle B 2610 x 2mx

B 28591 - 2mx mf. 06/09/28. (4)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

mf. 06/09/28. (4)

2-Spot Weld as per Dwg D3467 and Dart QSI 004

mf. 06/09/28. (4)

| | | |
|-----|--------|--------------------------------|
| 4.0 | QC5/11 | INSPECT WORK/INSPECT SPOT WELD |
|-----|--------|--------------------------------|

**Comment:** INSPECT WORK/INSPECT SPOT WELD

SB 06/10/02 (4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/10/03
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:30:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE & DEFLECTOR ASSEMBLY

Job Number: 28581

Part Number: D3467049

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5439

GA

TOOK

①

06/10/02 (y)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/03

①

Job Completion



u 86-10-03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

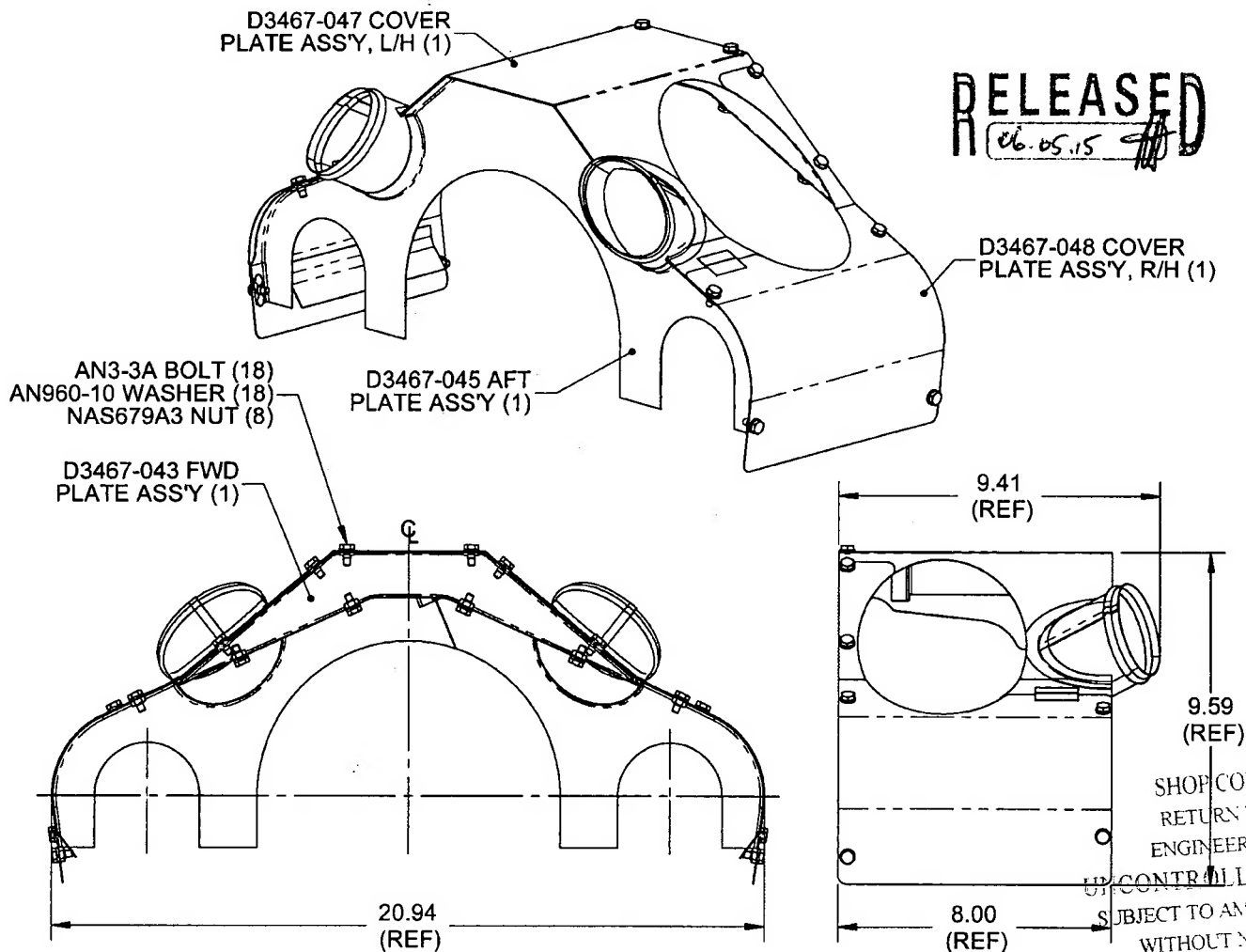
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries



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| DESIGN 13 | DRAWN BY 13 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3467 | REV. B SHEET 1 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:5 |
| A. | 05.12.07 | NEW ISSUE | |
| B. | 06.05.15 | Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F | |



D3467-041 SHROUD ASSEMBLY

NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

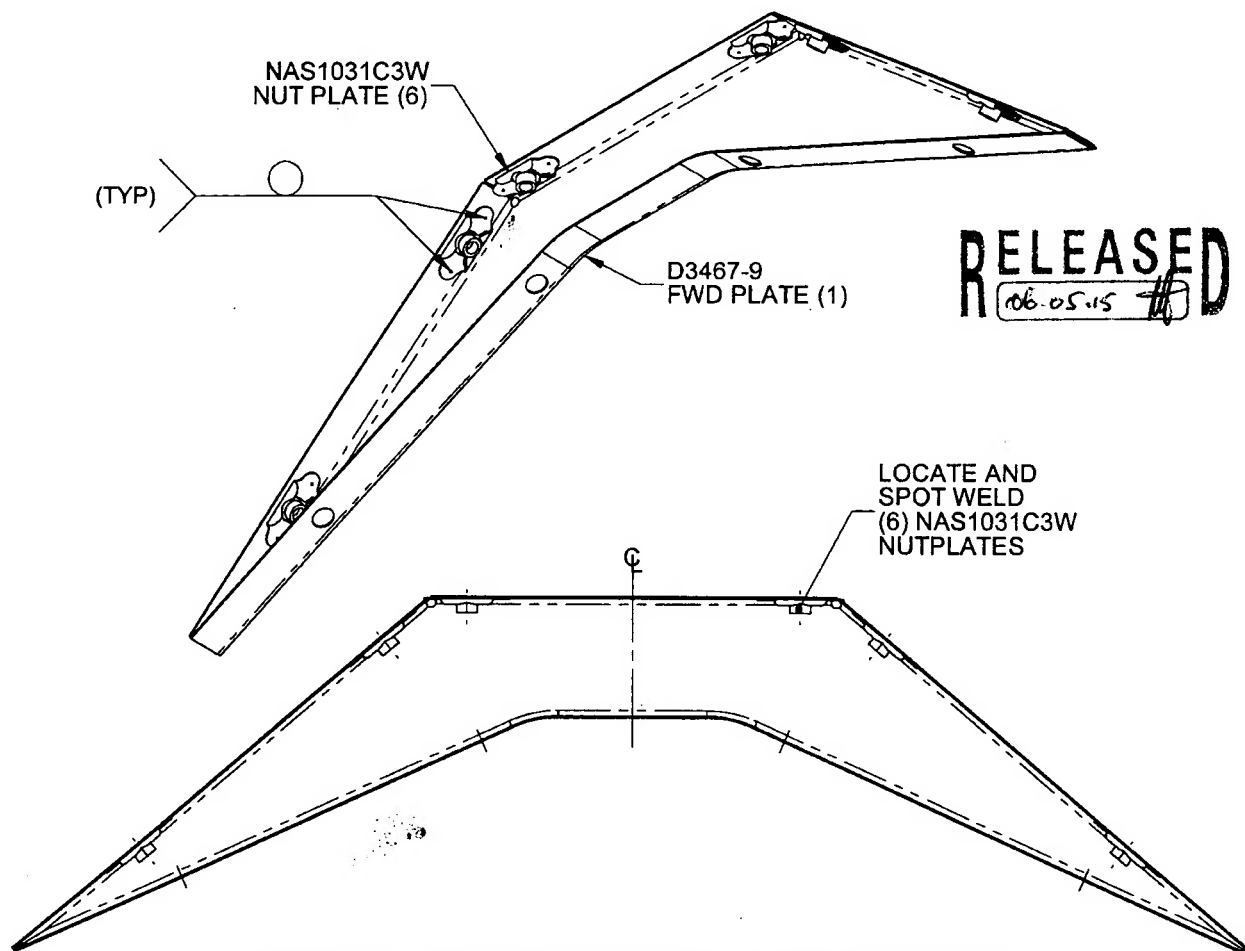
| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|---------------------------|
| X | D3467-041 | SHROUD ASSEMBLY |
| 1 | D3467-043 | FWD PLATE ASSEMBLY |
| 1 | D3467-045 | AFT PLATE ASSEMBLY |
| 1 | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| 1 | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 18 | AN3-3A | BOLT |
| 18 | AN960-10 | WASHER |
| 8 | NAS679A3 | NUT |

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| CHECKED # | APPROVED # | DRAWING NO. D3467 | REV. B SHEET 2 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |



| QTY -043 | P/N | DESCRIPTION |
|-------------|------------|--------------------|
| X | D3467-043 | FWD PLATE ASSEMBLY |
| 1 | D3467-9 | FWD PLATE |
| 6 | NAS1031C3W | NUT PLATE |

D3467-043 FWD PLATE ASSEMBLY**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

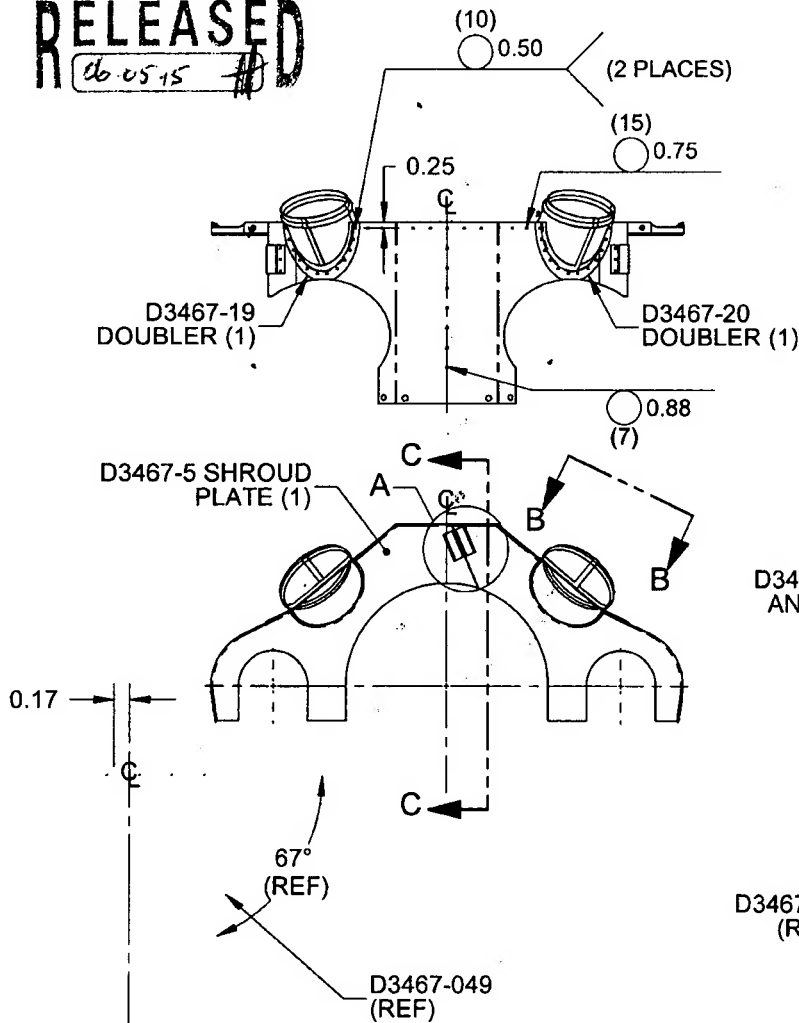
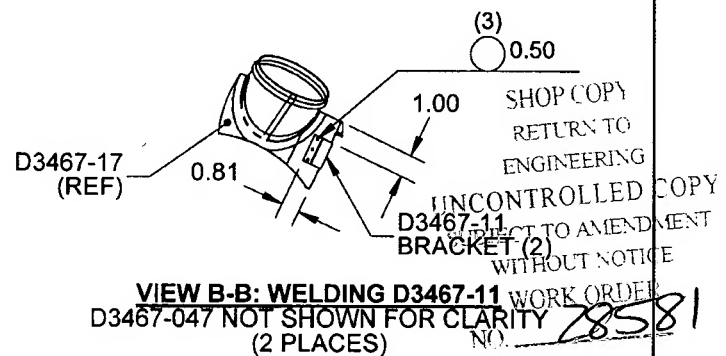
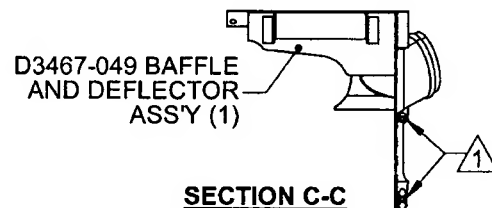
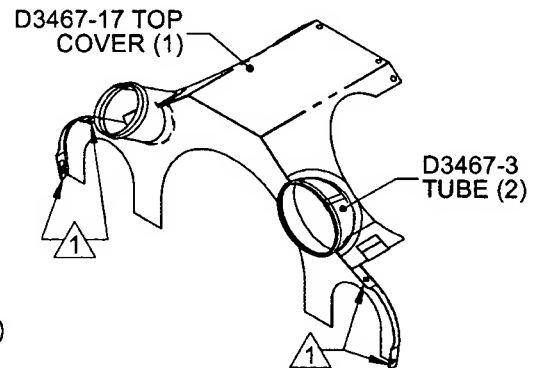
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:8 |

RELEASED
06.05.15**DETAIL A**
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -045 | P/N | DESCRIPTION |
|-------------|------------|-------------------------------|
| X | D3467-045 | AFT PLATE ASSEMBLY |
| 1 | D3467-049 | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2 | D3467-3 | TUBE |
| 1 | D3467-5 | SHROUD PLATE |
| 2 | D3467-11 | BRACKET |
| 1 | D3467-17 | TOP COVER |
| 1 | D3467-19 | DOUBLER |
| 1 | D3467-20 | DOUBLER |
| 4 | NAS1031C3W | NUT PLATE |

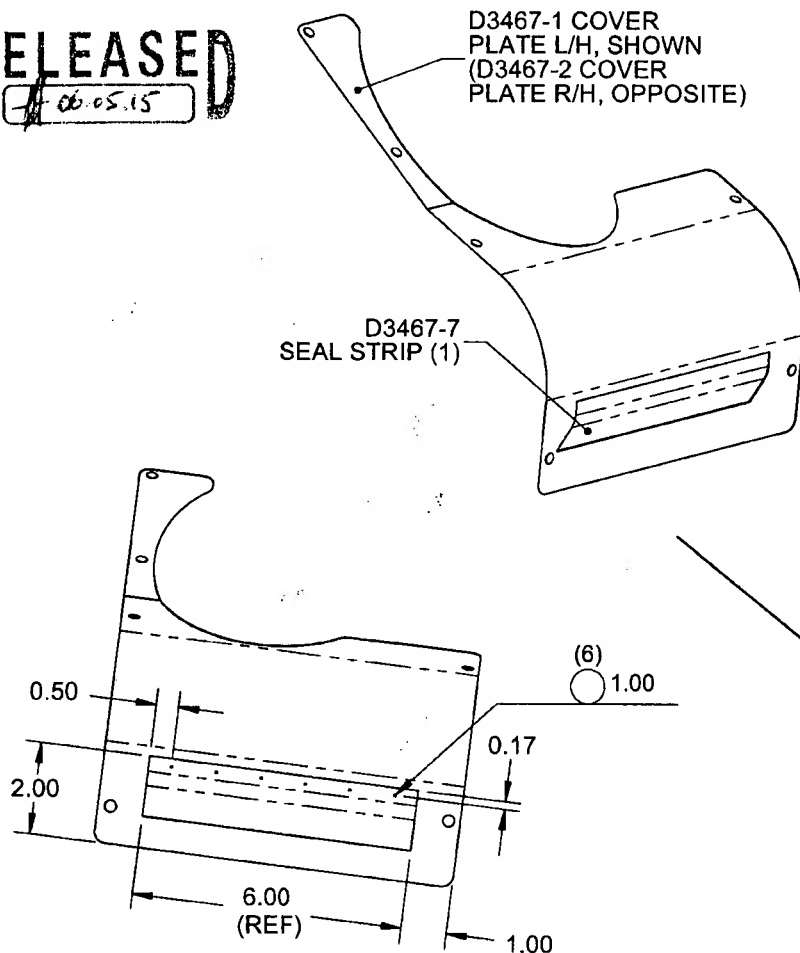
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

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06.05.15



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

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NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO
0.010

| QTY -047 | QTY -048 | P/N | DESCRIPTION |
|-------------|-------------|-----------|---------------------------|
| X | | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| | X | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1 | | D3467-1 | COVER PLATE, L/H |
| | 1 | D3467-2 | COVER PLATE, R/H |
| 1 | 1 | D3467-7 | SEAL STRIP |

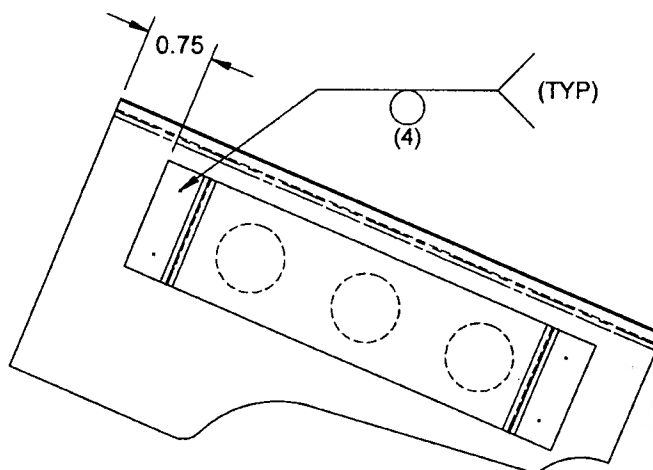
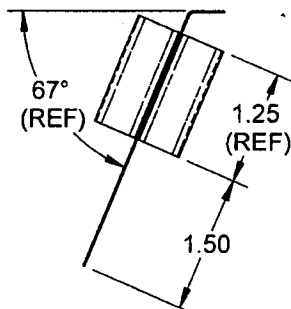
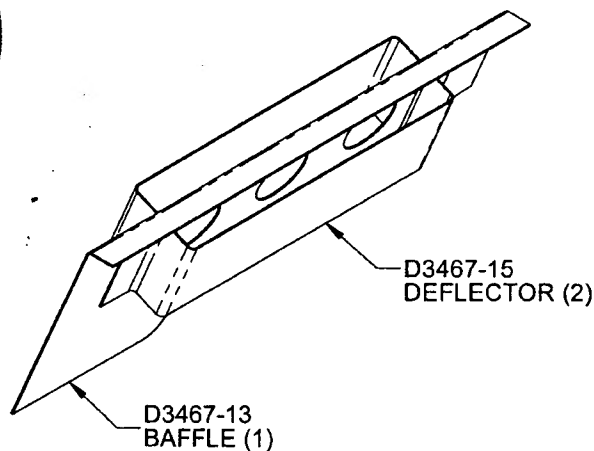
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

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D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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NO. 28581

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

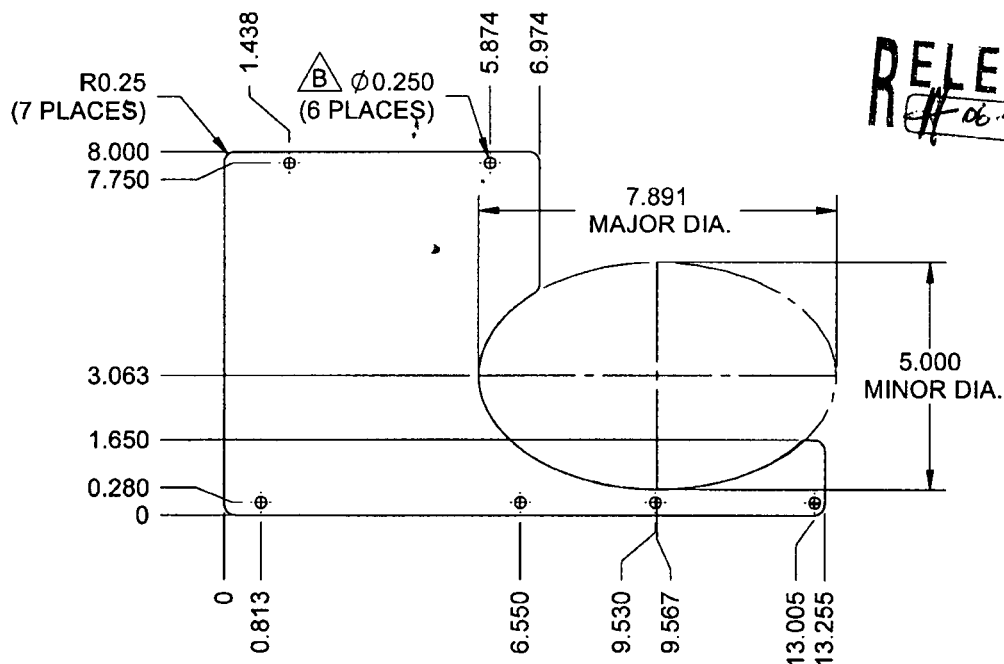
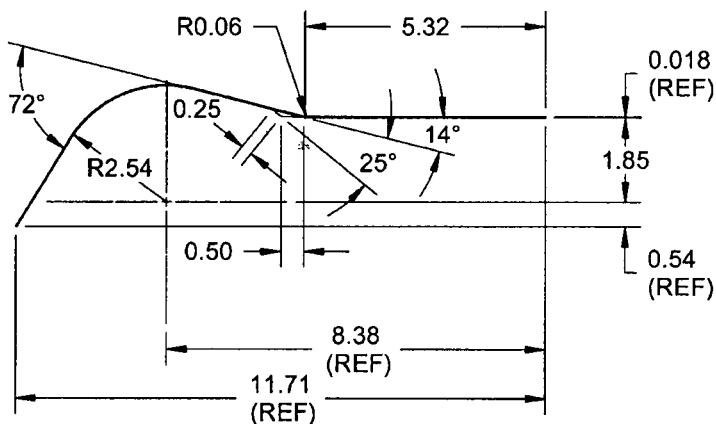
| QTY -049 | P/N | DESCRIPTION |
|-------------|-----------|-----------------------------|
| | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1 | D3467-13 | BAFFLE |
| 2 | D3467-15 | DEFLECTOR |

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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE
D3467-2 R/H COVER PLATE (OPPOSITE)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3467-1 L/H COVER PLATE ISOMETRIC VIEW,
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8 RETURN TO

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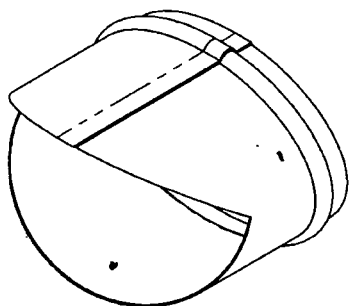
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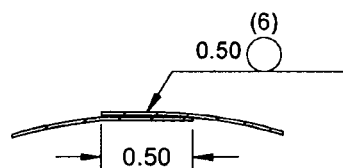
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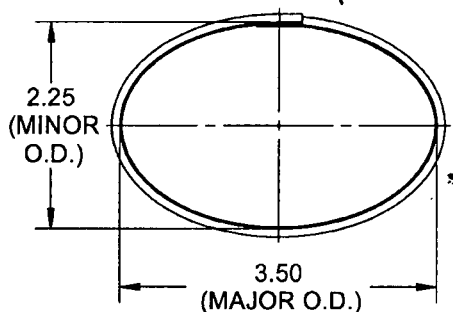
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |



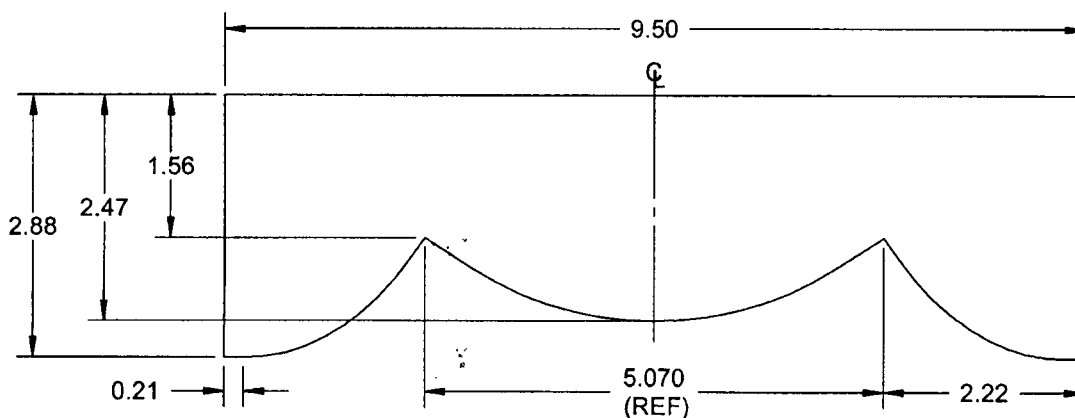
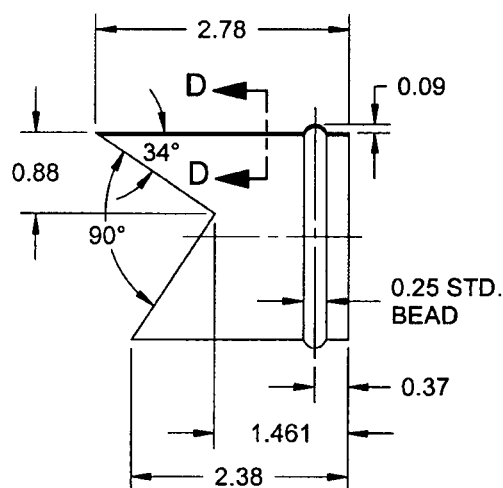
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06.05.15



SECTION D-D
SCALE 1:1



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

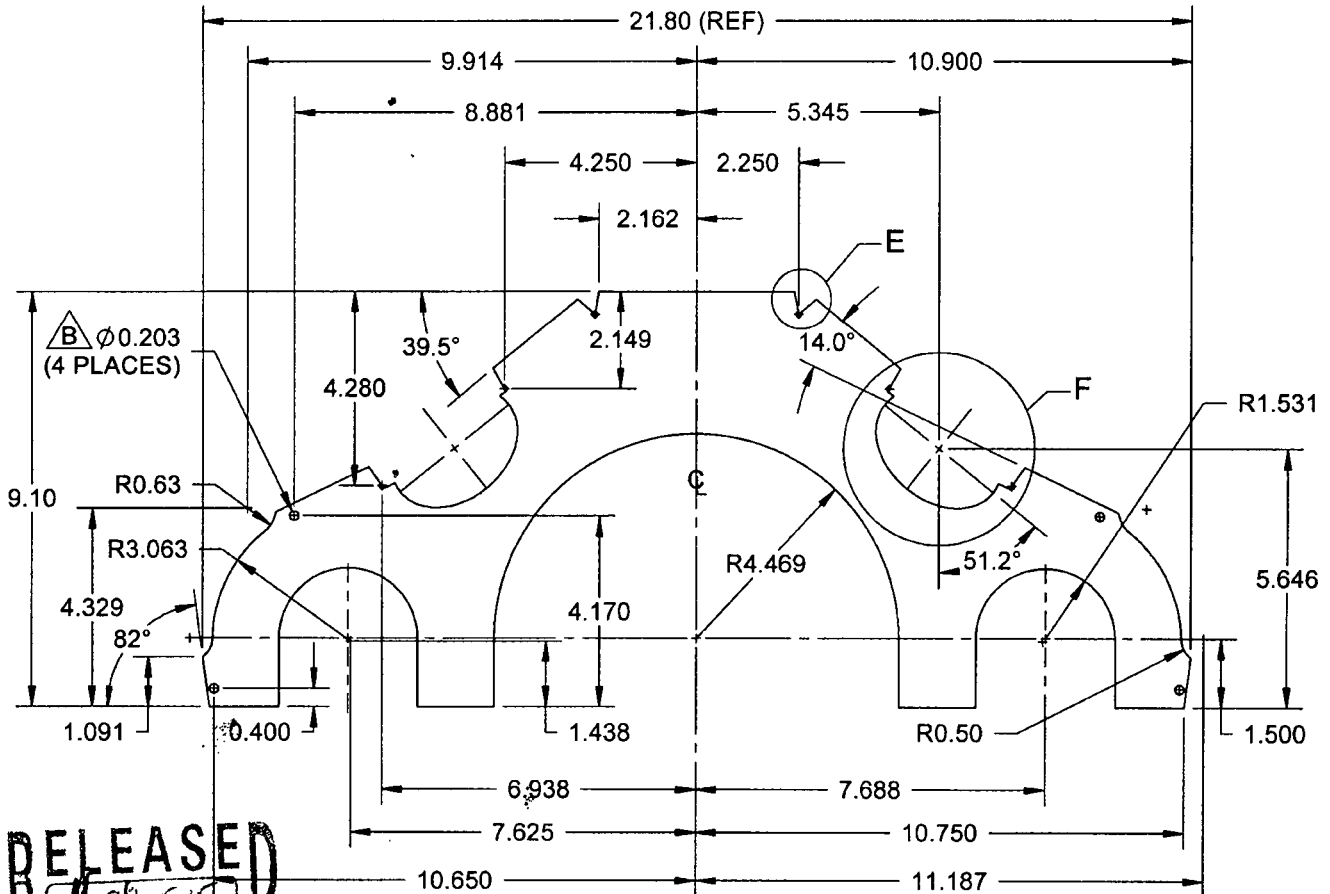
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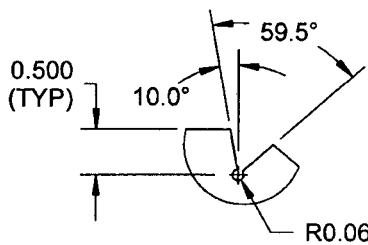
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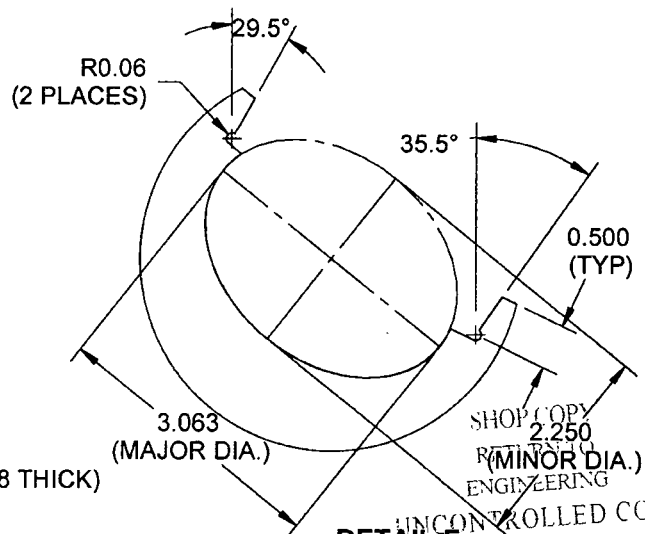
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:8 |



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DETAIL E
SCALE 1:2



DETAIL F
SCALE 1:2
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NO 28581

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

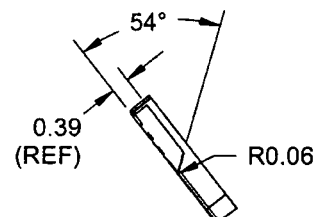
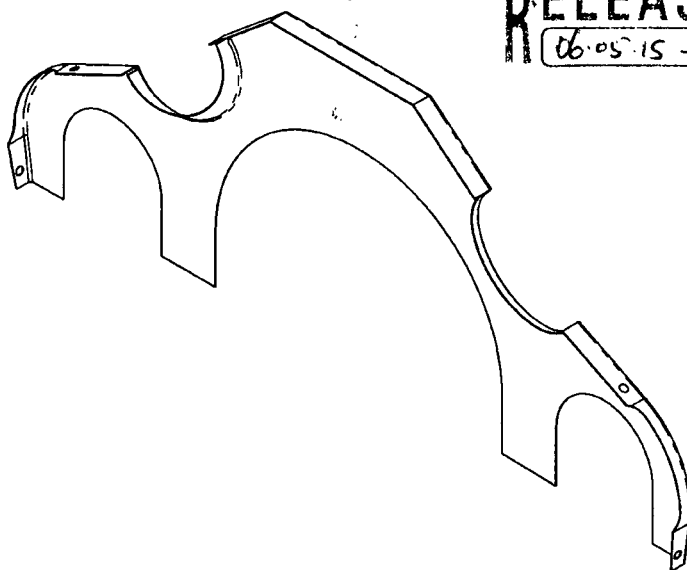
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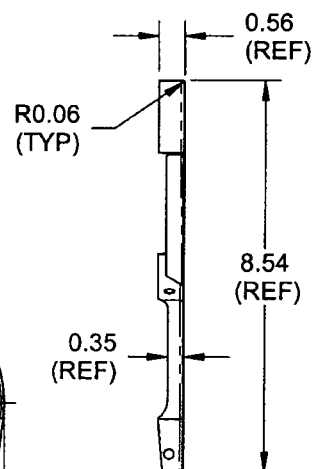
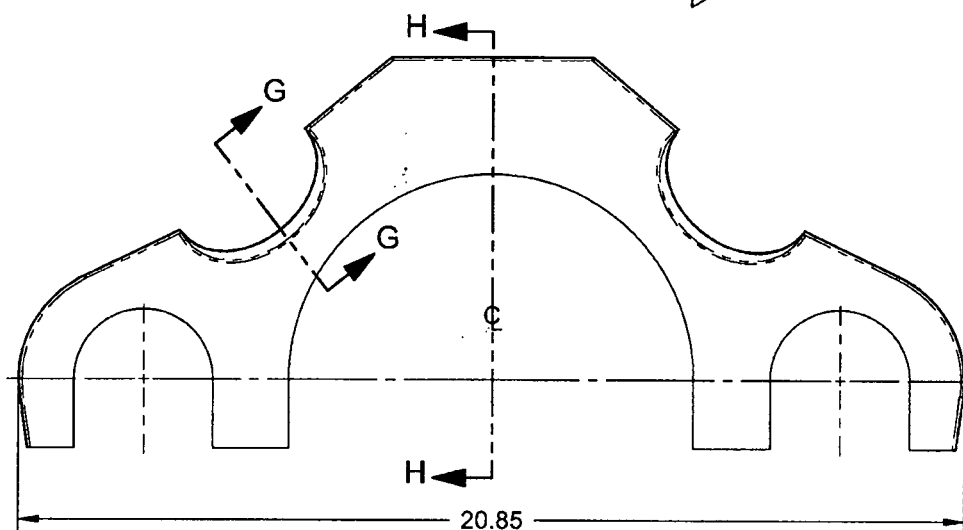


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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

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SECTION G-G



SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

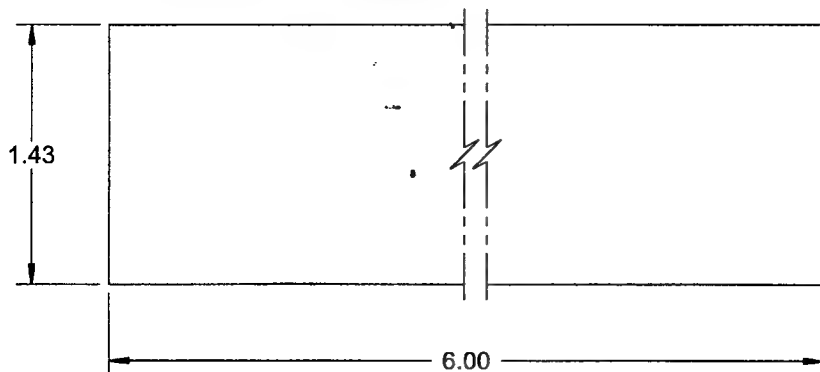
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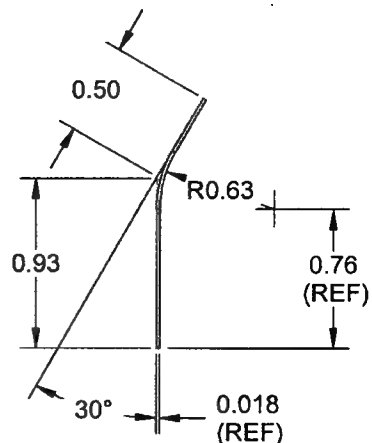
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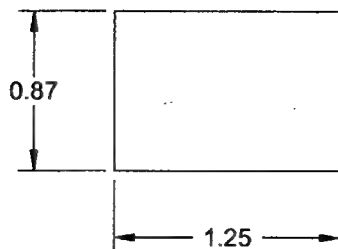
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| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3467 | REV. B SHEET 10 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:1 |

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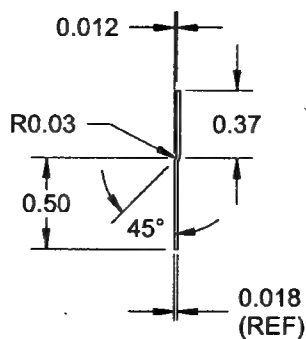
D3467-7F SEAL STRIP
FLAT PATTERN



D3467-7 SEAL STRIP
BENDING DETAIL



D3467-11F BRACKET
FLAT PATTERN



D3467-11 BRACKET
JOGGLE DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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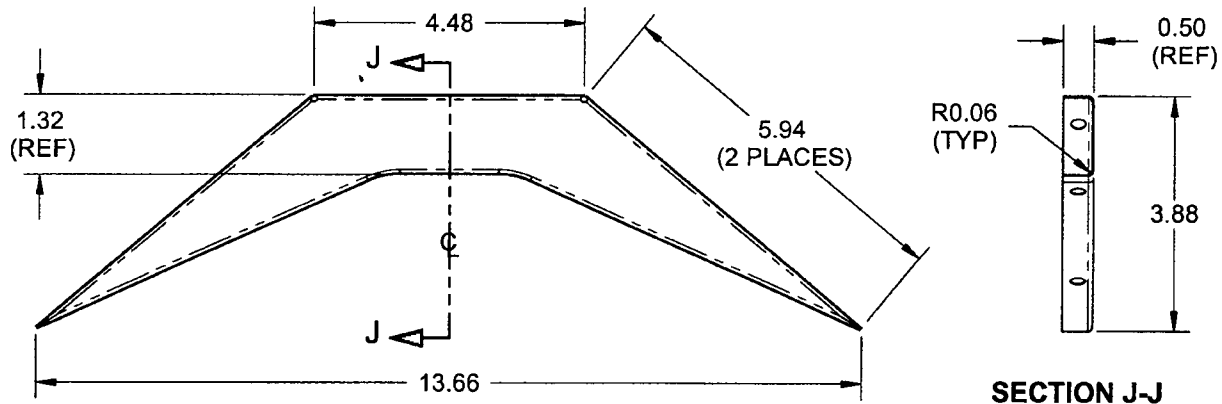
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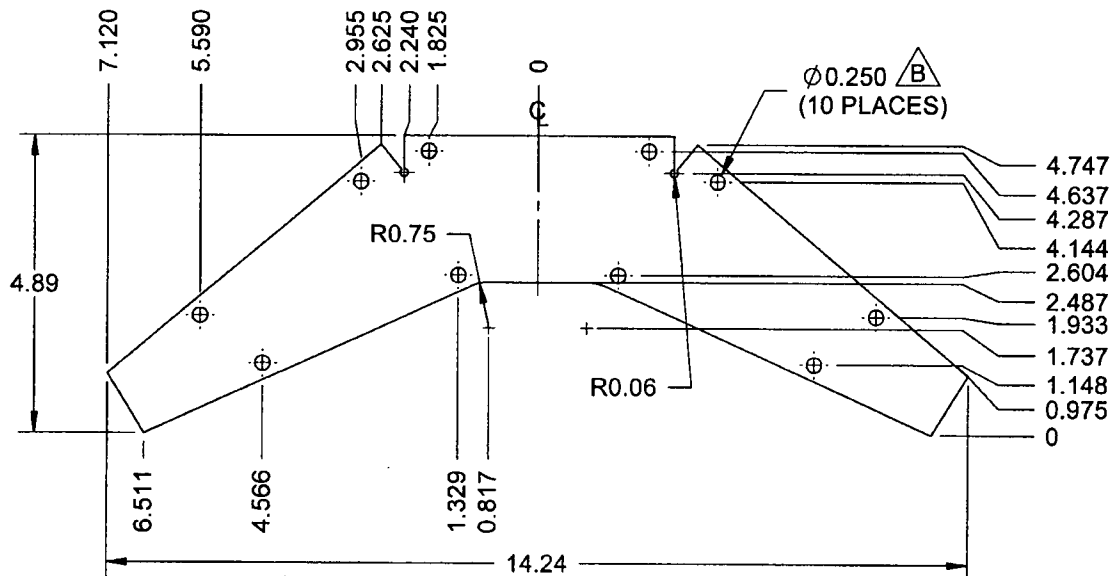


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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3467 | REV. B SHEET 11 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:3 |

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[Signature] 06.05.15



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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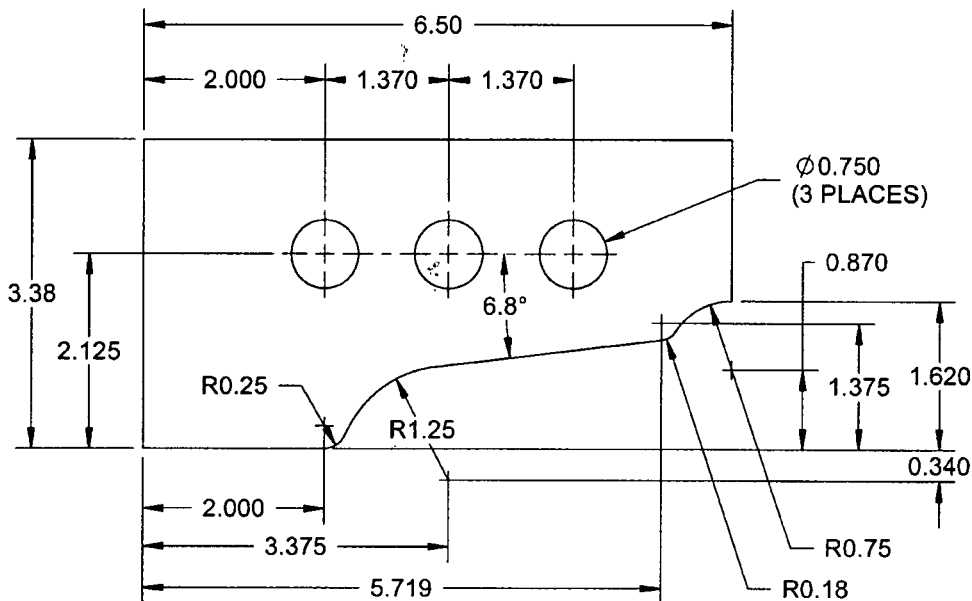
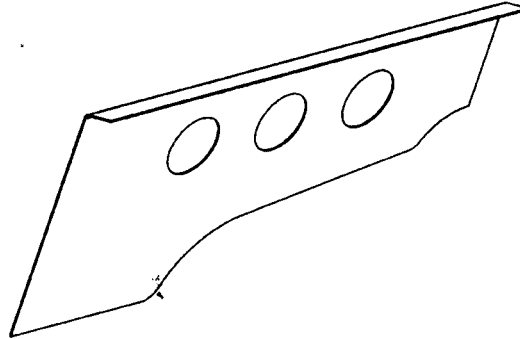
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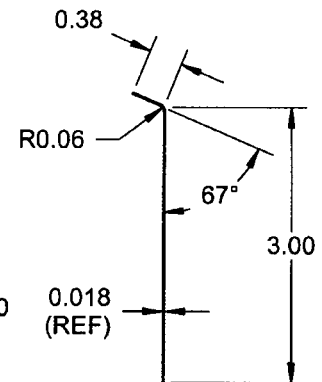


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| CHECKED 13 | APPROVED 13 | DRAWING NO. D3467 | REV. B SHEET 12 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

RELEASED
06 05 15



D3467-13F BAFFLE
FLAT PATTERN



D3467-13 BAFFLE
BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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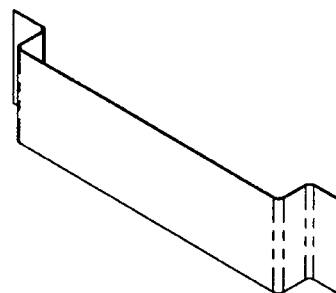
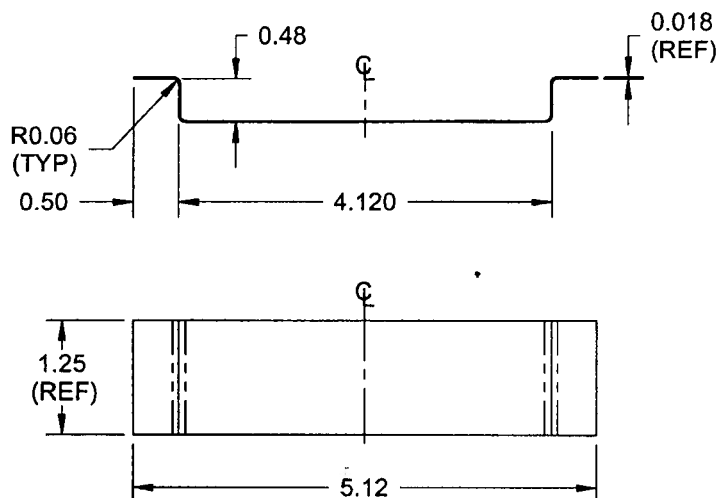
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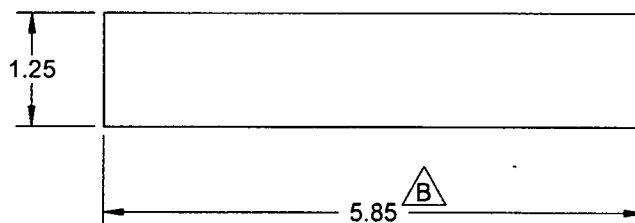


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| DESIGN B | DRAWN BY B | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

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06.05.15



D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

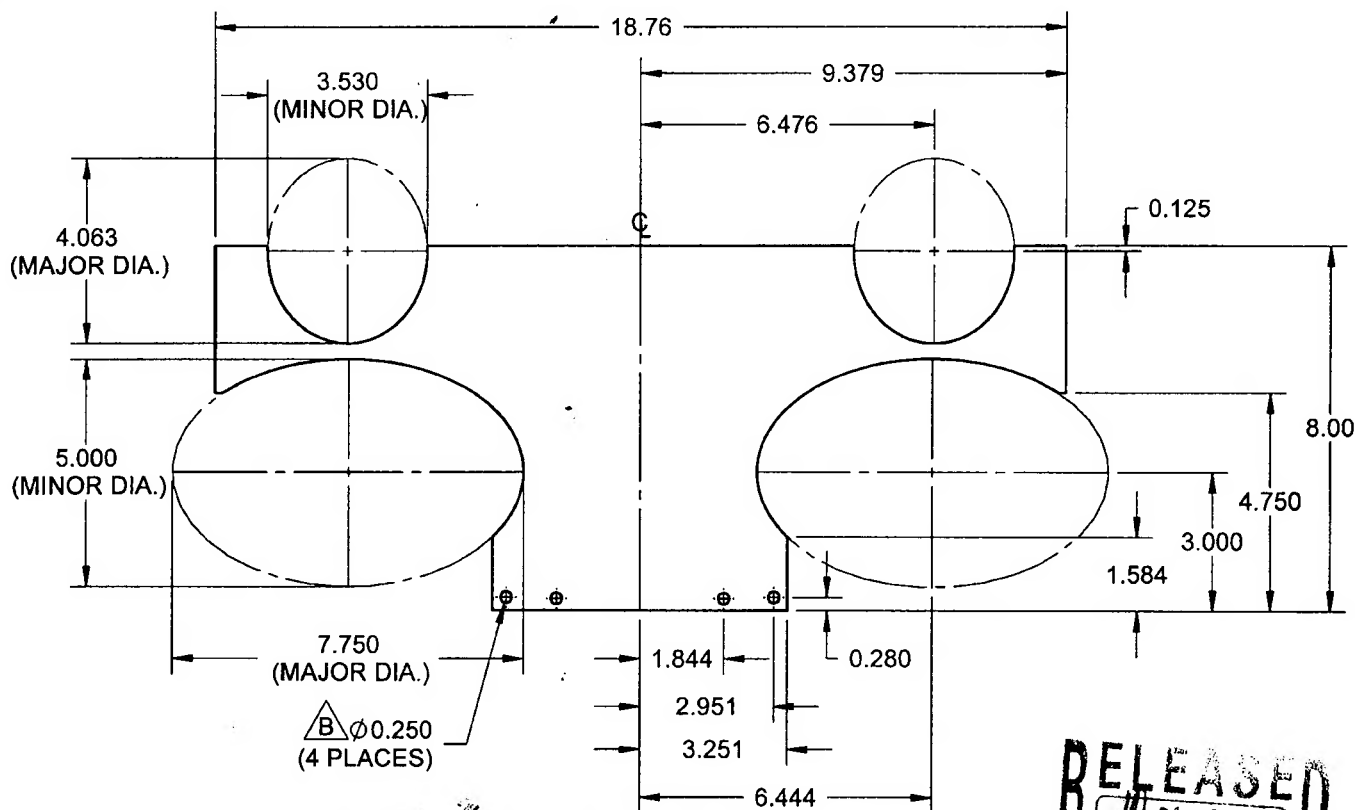
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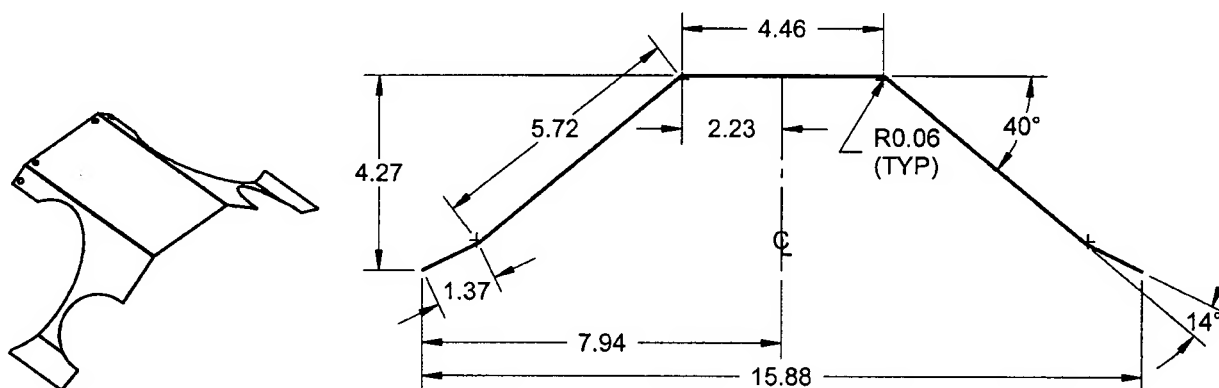


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| DATE 06.05.15 | TITLE SHROUD ASSEMBLY | | SCALE 1:4 |



D3467-17F TOP COVER FLAT PATTERN

RELEASED
[Stamp]



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **28581**

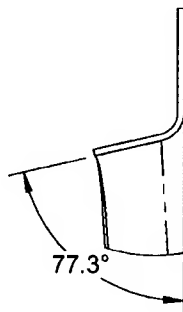
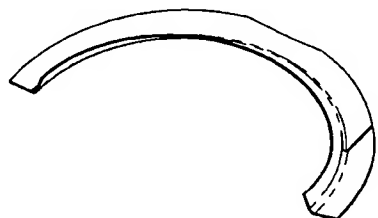
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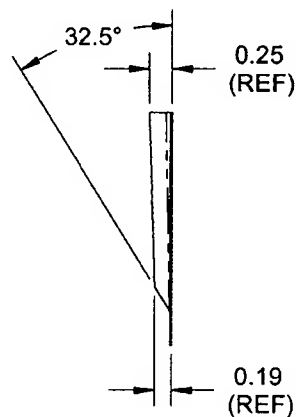
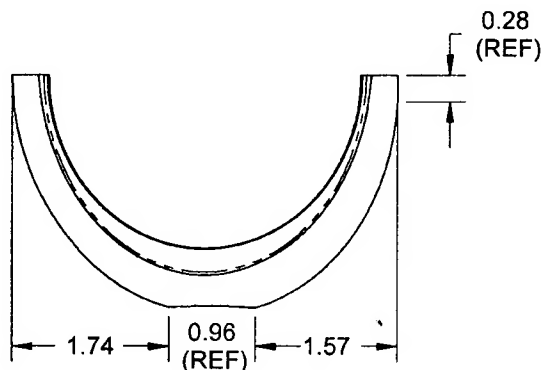
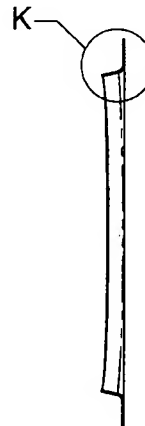


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| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

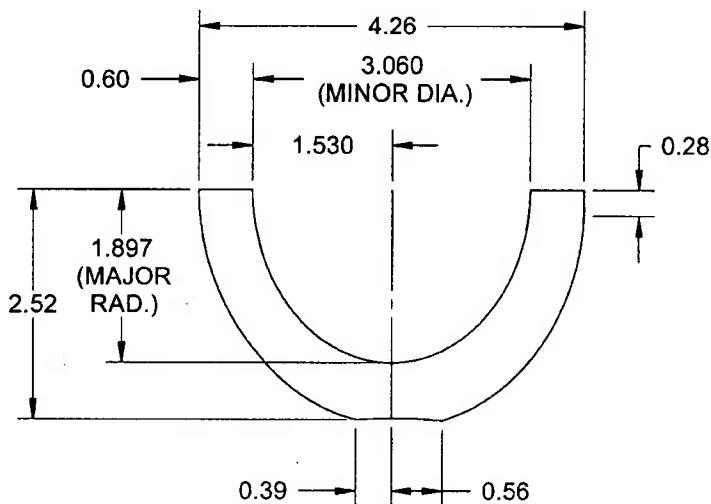
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DETAIL K
SCALE 1:2



D3467-19 DOUBLER, L/H SHOWN
D3467-20 DOUBLER, R/H OPPOSITE



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D3467-19F FLAT PATTERN

WORK ORDER
NO. **28581**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 14

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Melanie Fauteux

Joint Welding Procedure Spot Welding

Part number and Job number D 3467-049 B 28581 GTx 4

TEST WELDS REQUIRED

BASE METAL 304 2G WELDING PROCESS Spot
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |

W/A

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ *W/A*

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/02 Qualifier Sylvie Boucher